

Date: Wednesday, 23/08/2006 11:42:21 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 28254B	
Estimate Number : 10339	
P.O. Number : N/A	Part Number : D2658
This Issue : 23/08/2006 S.O. No. : N/A	Drawing Number : D2658 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 21/08/2006 Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 27219	Material : N/A
Written By : _____	Due Date : 12/09/2006 Qty: 30 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 05-11-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S12GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.1140 sf(s)/Unit Total: 3.4200 sf(s)
 1010/1025/A21/6aA SHEET

Batch # M101094

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

SAD 06:08:26

(30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:08:26

(30)

4.0	QC8	SECOND CHECK
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Comment: DIMENSIONAL CHECK
 Inspect dimensions per template D2658T1

06-08-29
 Count (30)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Deburr as required. SAD 06:08:30

(30)

2-Bend on CNC brake using DT8254 Identify as D2658

SB 06/09/13

(30)

Date: Wednesday, 23/08/2006 11:42:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 28254B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



2009-14 (30)



Comment: INSPECT WORK TO CURRENT STEP

7.0

DC

DOCUMENT CONTROL



(30)

Comment: DOCUMENT CONTROL
Inspection Level 21

Doc/09/19

Job Completion



6.1

Identify and stock.

Location

WS

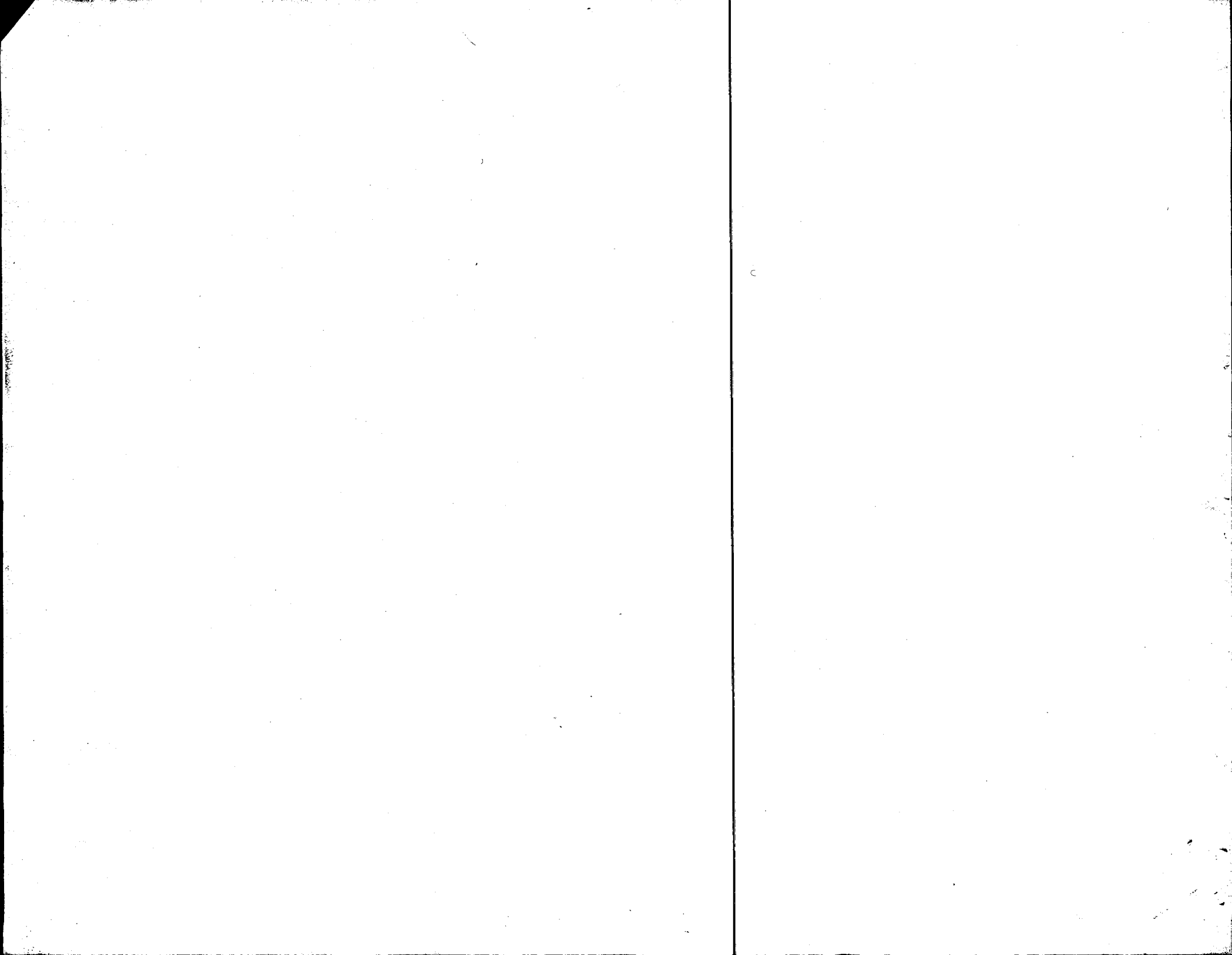
Qty

30

06/09/18

(PTO)

U 06-09-19



Date: Monday, 8/21/2006 2:11:37 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 28254B		
Estimate Number	: 10339		
P.O. Number	:	Part Number	: D2658
This Issue	: 8/21/2006 S.O. No. :	Drawing Number	: D2658 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: 27219	Material	:
Written By	: <u> </u>	Due Date	: 9/12/2006 Qty: 30 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est Rev:A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING
Issue P/O: _____
Laser cut per Drawing Flat pattern D2658
Material release note required

114 SF. waterjet

2.0	D2658F	Lug Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)
Lug Bracket

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
Inspect dimensions per template D2658T1

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
1-Deburr as required.

2-Bend on CNC brake using DT8254 Identify as D2658

PTC
→

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-09-14	6.1	Add I.D. : stock. Perm. Change	[Signature]	06-09-28			[Signature] 06-09-14	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/27
QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:11:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 28254B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

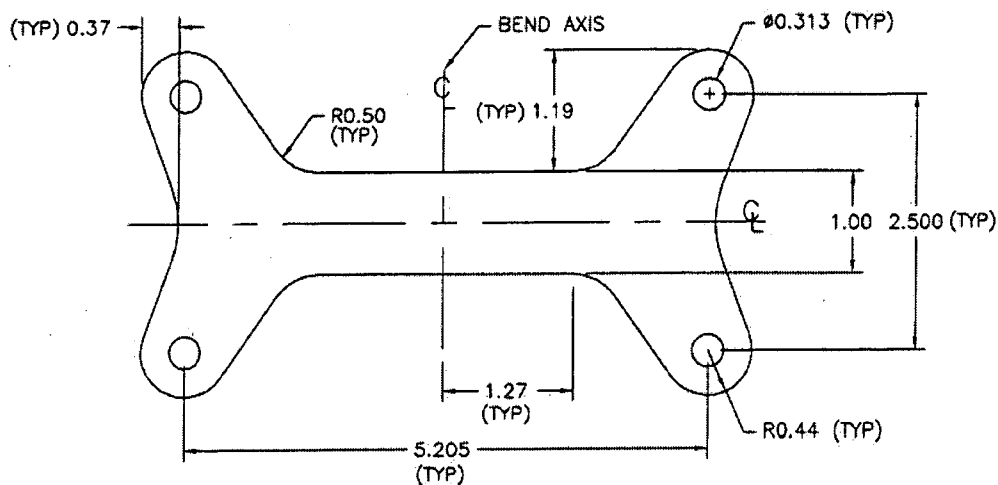
NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

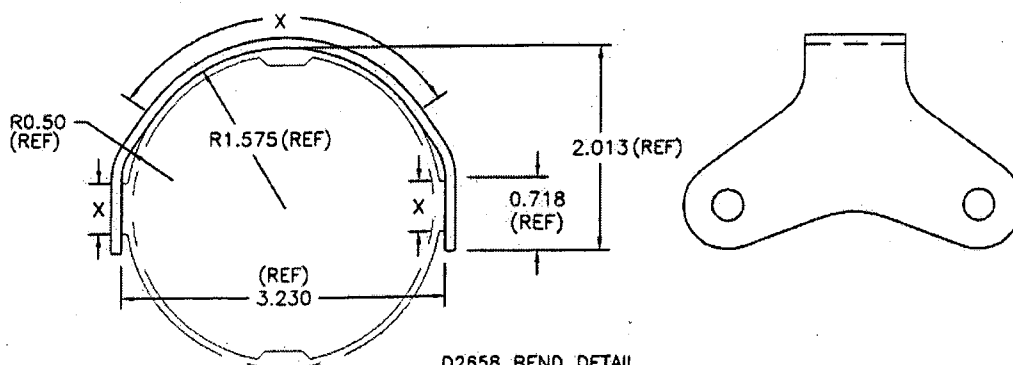


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2658	REV. D SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28254B

